

Date: Tuesday, 1/31/2006 11:03:17 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GHW MEDIUM BELL	
Job Number	: 25682		Part Number	: D412729041	
Estimate Number	: 12129		Drawing Number	: DSK 092 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/31/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : LARGE FAB ASSY		Due Date	: 2/28/2006 Qty: 1 Um: Each	
Previous Run	: 25681				
Written By	<u>SPE COMMENT BELOW</u>				
Checked & Approved By	<u>KJ 06.01.31</u>				
Comment	: Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D27287	Decal	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2728-7 Label <u>322554</u>	<i>CPL 06-02-09</i>
2.0	D3233041	Wheel Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-041 Wheel Assembly <u>323577C</u>	<i>CPL 06-02-09</i>
3.0	D32331	Inside Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-1 Inside Washer <u>323040</u>	<i>CPL 06-02-09</i>
4.0	D32333	Outside Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-3 Outside Washer <u>323041</u>	<i>CPL 06-02-09</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/31/2006 11:03:18 AM
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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D33091	Label
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3309-1 Label <u>B22109</u> CPC 06-02-13
6.0	D33093	Label
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3309-3 Label <u>B23768</u> CPC 06-02-13
7.0	D3330041	Frame Weldment
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)- Pick: Qty Part Number Description Batch 1 D3330-041 Frame Weldment <u>B2301bc B25639</u>
8.0	D3331041	Handle Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3331-041 Handle Assembly <u>B23568 B23769B</u> CPC 06-02-09
9.0	D3332041	Pin Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3332-041 Long Pin Assembly <u>B23018 B23770</u> CPC 06-02-09

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 D3332043 Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly B23019 B23771 CPC 06.02.09

11.0 D33331 Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate B23055 CPC 06.02.09

12.0 D33333 Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate B25684 CPC 06.02.23

13.0 D33335 Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail B23056 CPC 06.02.09

14.0 D33341 Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft B25686 B230228 CPC 06.02.10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 D33351 Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring B22256

CPL 06-02-09

16.0 D33353 Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B22256

CPL 06-02-09

17.0 D33361 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B23772A

CPL 06-02-10

18.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M10431

CPL 06-02-13

19.0 CP21 1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span M16301

CPL 06-02-13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Drawing Name: GHW MEDIUM BELL

Job Number: 25682

Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 HC12 1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span

N/A

n

21.0 HC29 5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof

M19705

CPL 06-02-13

22.0 HC153 3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-153 3/8"-24 UNF x 1.25" long Hex Bolt, Span

M17356

CPL 06-02-10

23.0 HN120 HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-120 1" Slotted Nut, Prof

M18162

CPL 06-02-10

24.0 HN177 5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-177 5/16"-18 UNC Nylon Lock Nut, Span

M14626

CPL 06-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Job Number: 25682

Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation:

Description :

25.0 HX15 1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span

M16626

CPL 06.02.13

26.0 MS21042L5 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

M169073

CPL 06.02.13

27.0 2333 1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span

M16154

CPL 06.02.10

28.0 18SNB 3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span

M1619705

CPL 06.02.13

29.0 113803 1/8" PTF Grease Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span

19705 M16640 M16533

CPL 06.02.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: GHW MEDIUM BELL

Job Number: 25682

Part Number: D412729041

Job Number:



Seq. #:	Machine Or Operation:	Description :
30.0	656036	Inventory

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 656-036 5/16" Type B Flat Washer (Narrow), Prof

17583
M4611

CPL 06.02.23

31.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

CPL 06.02.22

32.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

J 06.02.27

33.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 06/02/28

①

Job Completion



U 06.03.01

Level 21 inspection

S 06/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

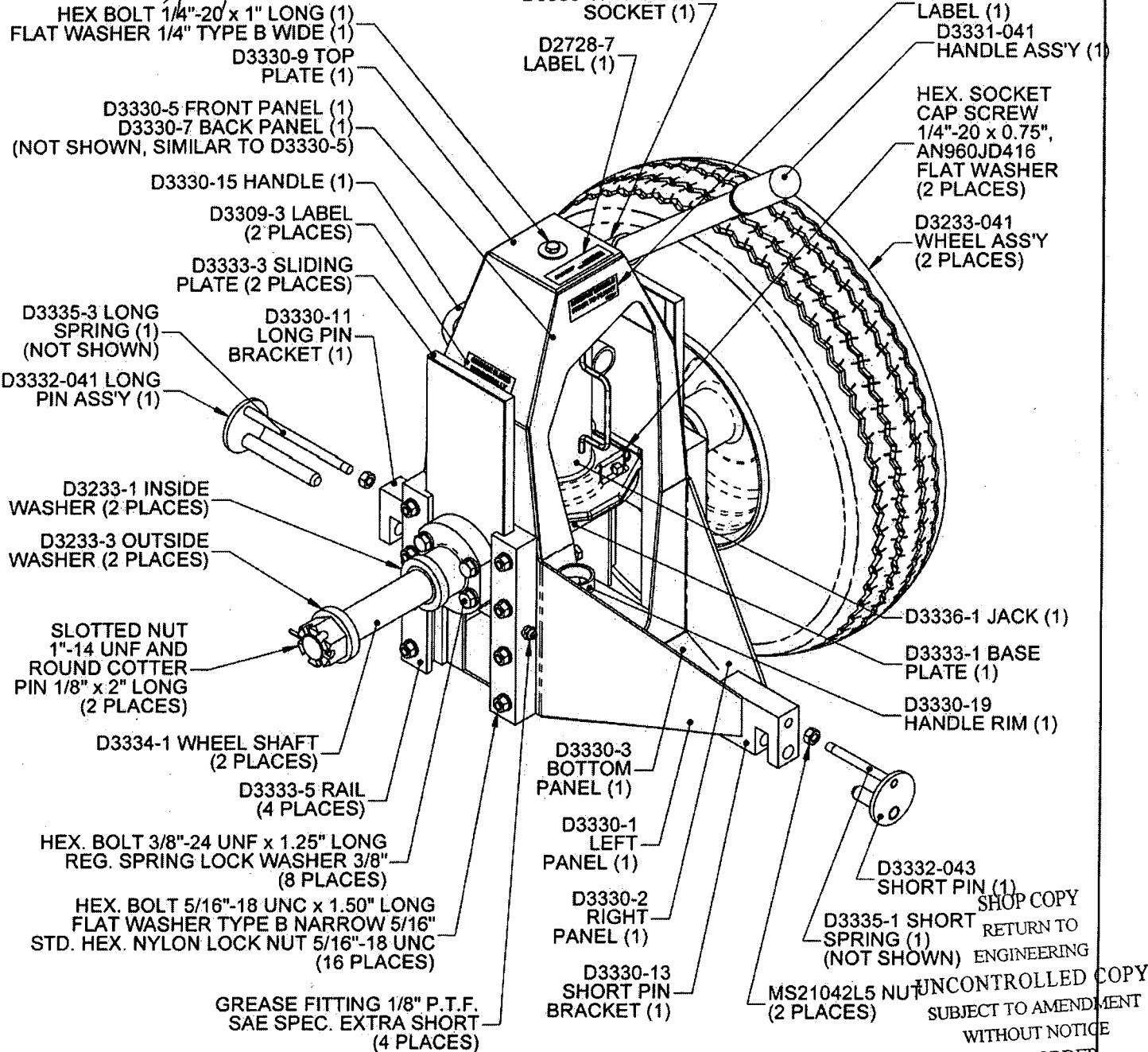
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>JW</i>	DRAWN BY <i>JW</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>JW</i>	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE	05.02.18	TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED
05/02/18**NOTE:**

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. NO. 25682
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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